

## ABSTRACT OF THE DISCLOSURE

An assembly for can manufacture includes a toolpack having coolant dies (3,4,5,6) adjacent and either side of ironing dies (1,2) so that coolant may be circulated around cavities in the coolant dies so as to cool the ironing die inserts (12). Generally, the toolpack is used in conjunction with a ram (20), coolant tube assembly (30) and ram guidance assembly (60) which together ensure that the ram is cooled along its entire length, up to and including the punch nose (21).